

Dereu 56485

Work Order ID 53474

November 6, 2009 8:39:51 AM



Page 1

Item ID:	D3391-021	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Fwd Tube Assembly					
Start Date:	05/11/2009	Start Qty:	1.00			
Required Date:	13/11/2009	Req'd Qty:	1.00			
Reference:						



Approvals:	Process Plan:		Date:	11-5	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								

100 0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut extrusion to 46.52 +0.010 -0.020

11-23

110 0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391 Using Bend Prog 3391021

1 11/11/24

120 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

$h = 6.740''$
 $L = 12.8''$

801/11/24



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Page 2

Item ID: D3391-021
Revision ID: H
Item Name: Fwd Tube Assembly

Accept



Setup Start



Stop



Start Date: 05/11/2009 Start Qty: 1.00
Required Date: 13/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA590 Rev. <u>AA</u> & Dwg D3391 Rev. <u>H</u> Identify as D3391-1 2-Deburr	0.00 0.00		<i>S.F 09/12/08</i>		<u>1</u>	<u>0</u>		
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>SF 09/12/08</i>		<u>1</u>	<u>0</u>		
150 Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo Drill X1 Aft cap as per Dwg D3391 .1875" dia	0.00 0.00		<i>mms 09/12/08</i>		<u>1</u>	<u>0</u>		

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Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 05/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				1	2		
170 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							

POSITIVE RECALL

EFFECTIVE 09.12.14 AUTH

RELEASED 10.02.16 DATE

★ TEST FIT REQ'D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-021 PAR #: _____ Fault Category: machined parts NCR: (Yes) No DQA: _____ Date: 10-03-02
 Resolution: Accepted Disposition: use as is QA: N/C Closed: X Date: 10/03/02

NCR: <u>53474</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.12.14	130	Section B-B, Dim 3.590 is 3.618 was recorded wrong on Pos sheet	CP 09.12.14 per QSI 042	Acceptable with benefit if test fit successful. PLACED ON POSITIVE RECALL QSI 042	CP 10.02.16 per QSI 042	/1002-23	CP 09.12.14 per QSI 042	S 10/02/17
		R.C. Lack of attention.		→ OK CP 10-02-16 Part was 0.002" over tol.				

NOTE: Date & initial all entries

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Item ID: D3391-021

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Revision ID: H

Item Name: Fwd Tube Assembly

Start Date: 05/11/2009 Start Qty: 1.00

Required Date: 13/11/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

BE 10/02/16

10/2/17

S 10/02/17

Ⓢ

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Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 05/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 11/01/2/17

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/01/2-17

220

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-instal spacers as per dwg D3391
A/R Magnabond 6398 batch: 11/24/17 11/01/2/17
exp. date: 11/1/32
cure time 12hrs. as per QSI015
2- grind crossbolt flush
3-back drill crossbolt if necessary) 11/01/2/18

1

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Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 05/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

255

0.00



Skidtubes

0.00

Skidtubes

Memo

Skidtubes

**** install D3591-1 spacer as per DS19364 and wearplate and gasket as per
DWG ****

BR 10-02-23.

257

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

S 12/02/24

HL

260

0.00



Identify as per dwg & Stock Location: 36406

0.00

Packaging

Memo

Packaging

BR 10-02-24.

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Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 05/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/24

MF 10-2-24

Picklist Print

Page 1

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Work Order ID: 53474

Parent Item: D3391-021RevH

Parent Item Name: Fwd Tube Assembly

Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6013-047RevA		Manufactured	No			100	Each	57.0000	1.0000			

Skidtube Material

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

57

23935

5

26547

52

255

Each

131.0000

4.0000

D3670-4-200RevA

Manufactured

No



SPACER

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

131

46106

4

48198

42

48269

85

255

Each

22.0000

1.0000

D3401-041RevB

Manufactured

No



Tow Cap Assembly

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

22

36216

1

41931

5

46029

16

9-11-23

2
2 11/10/21/17

1 10-02-23



Picklist Print

Page 2

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Work Order ID: 53474

Parent Item: D3391-021RevH

Parent Item Name: Fwd Tube Assembly

Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			255	Each	54.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP17	42	
51611 ✓	32	
52059	10	
Main Warehouse		
ST	12	
45409	2	
46495	10	

D3566-13RevC

Manufactured No

255

Each

31.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	29	
51606	29	
Main Warehouse		
ST	2	
45717	1	
50265	1	
* 53461		

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Shop Packet Print

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Picklist Print

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Work Order ID: 53474

Parent Item: D3391-021RevH

Parent Item Name: Fwd Tube Assembly



Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			255	Each	3,956.000	10.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE 113288		
FG	100	
103585	100	
Main Warehouse		
ST	3856	
112116	628	
112612	2228	
112933	1000	

10 BR 10-02-23.

AN3C4A  BOLT		Purchased	No			255	Each	994.0000	10.0000			
--	--	-----------	----	--	--	-----	------	----------	---------	---	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	994	
112314	13	
112720	12	
112724	3	
112794	366	
112829	500	
112991	100	

10 BR 10-02-23.

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Shop Packet Print

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Picklist Print

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Work Order ID: 53474

Parent Item: D3391-021RevH

Parent Item Name: Fwd Tube Assembly

Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB		Manufactured	No			255	Each	1,860.000	4.0000			
Phenolic Washer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1360

39275

19

42329

5

47628

336

52505

1000

Main Warehouse

ST117

500

51674

500

AELS-1032-130

Purchased

No

255

Each

0.0000

2.0000



INSERT

AELS-1032-225

Purchased

No

255

Each

0.0000

10.0000



INSERT

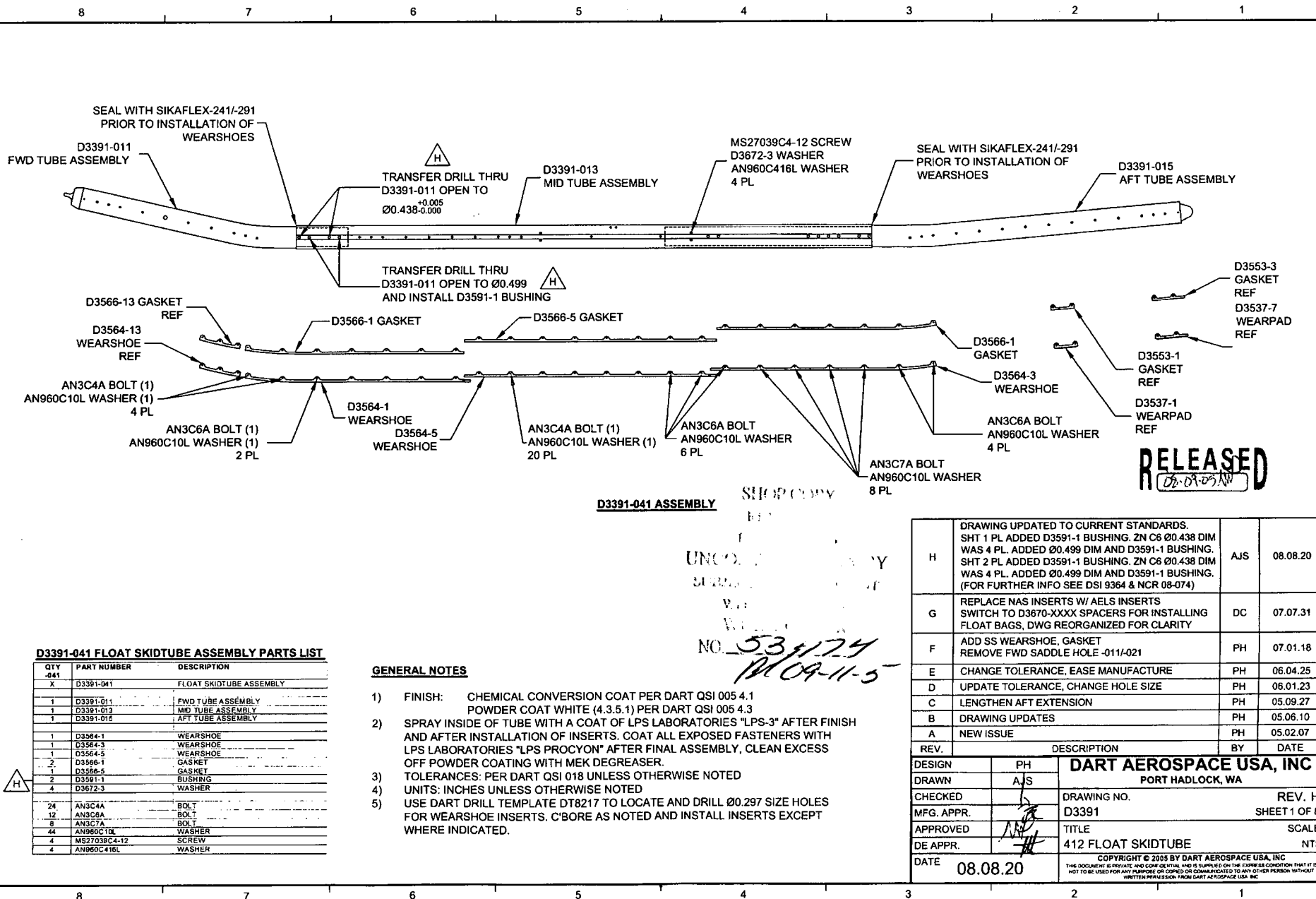
M110511.

* M110768.

4. BR 10-02-23.

2 BR 10-02-23.

10 BR 10-02-23



D3391-041 ASSEMBLY

SHOP COPY

UNCONTROLLED COPY

NO. 53174
10-09-11-5

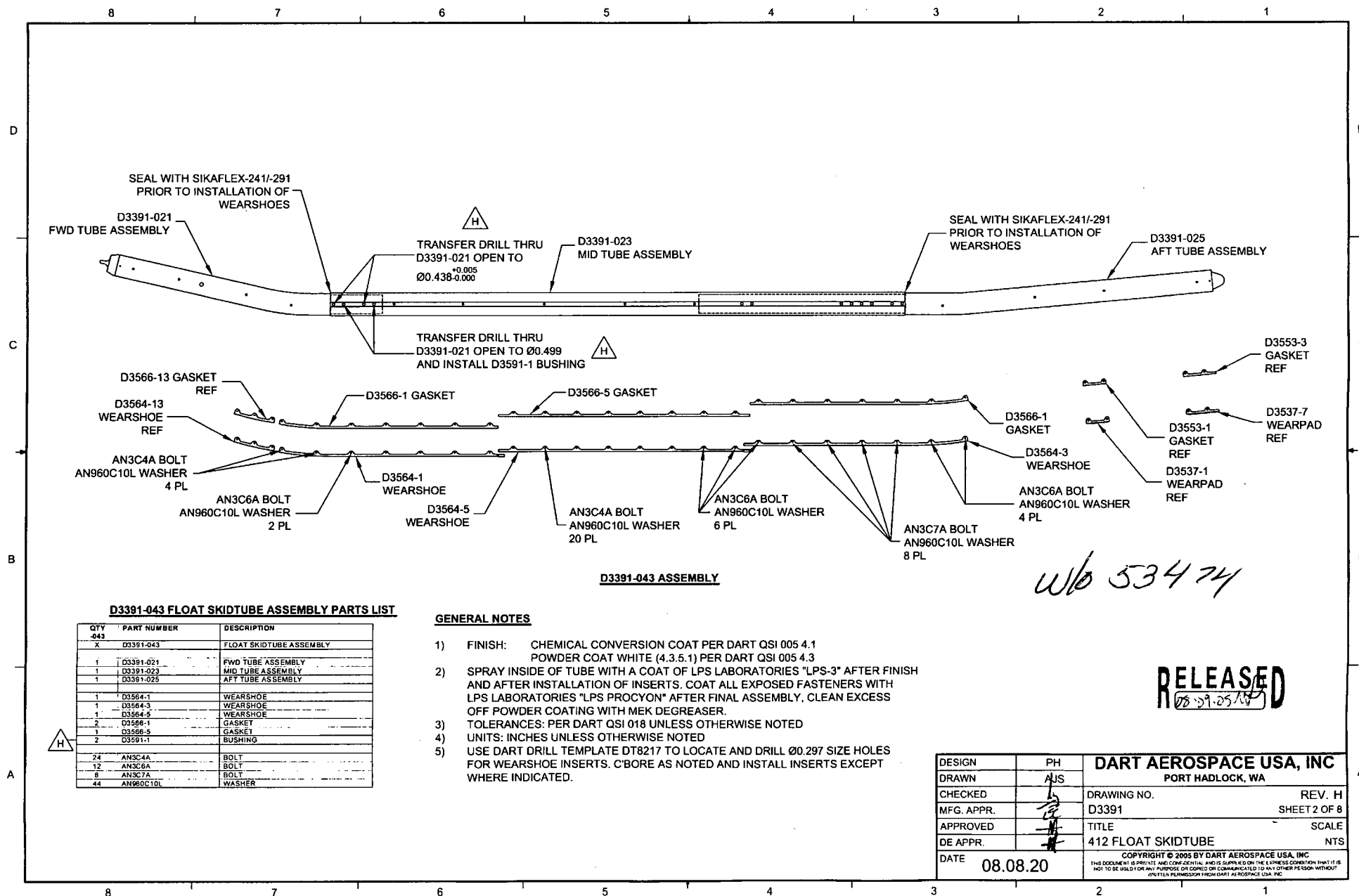
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small> COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	



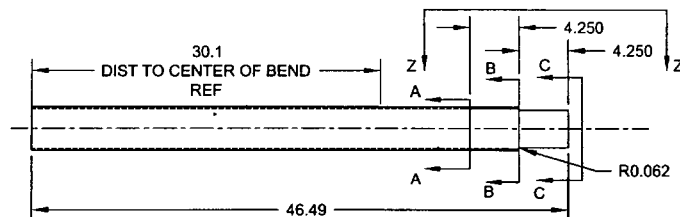
D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

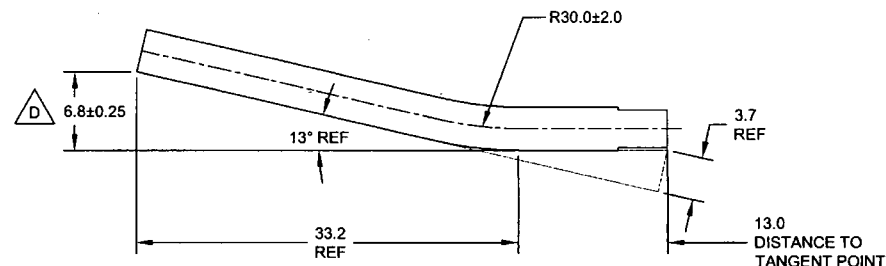
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

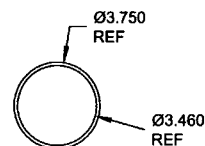
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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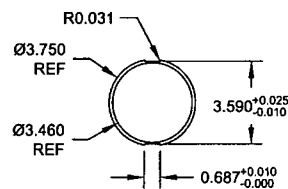
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



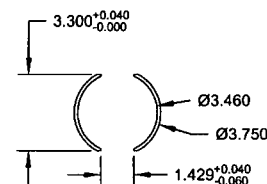
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



SECTION A-A
SCALE 2X

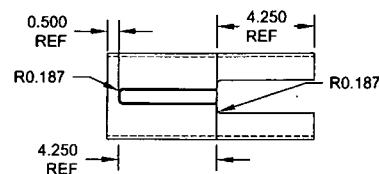


SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

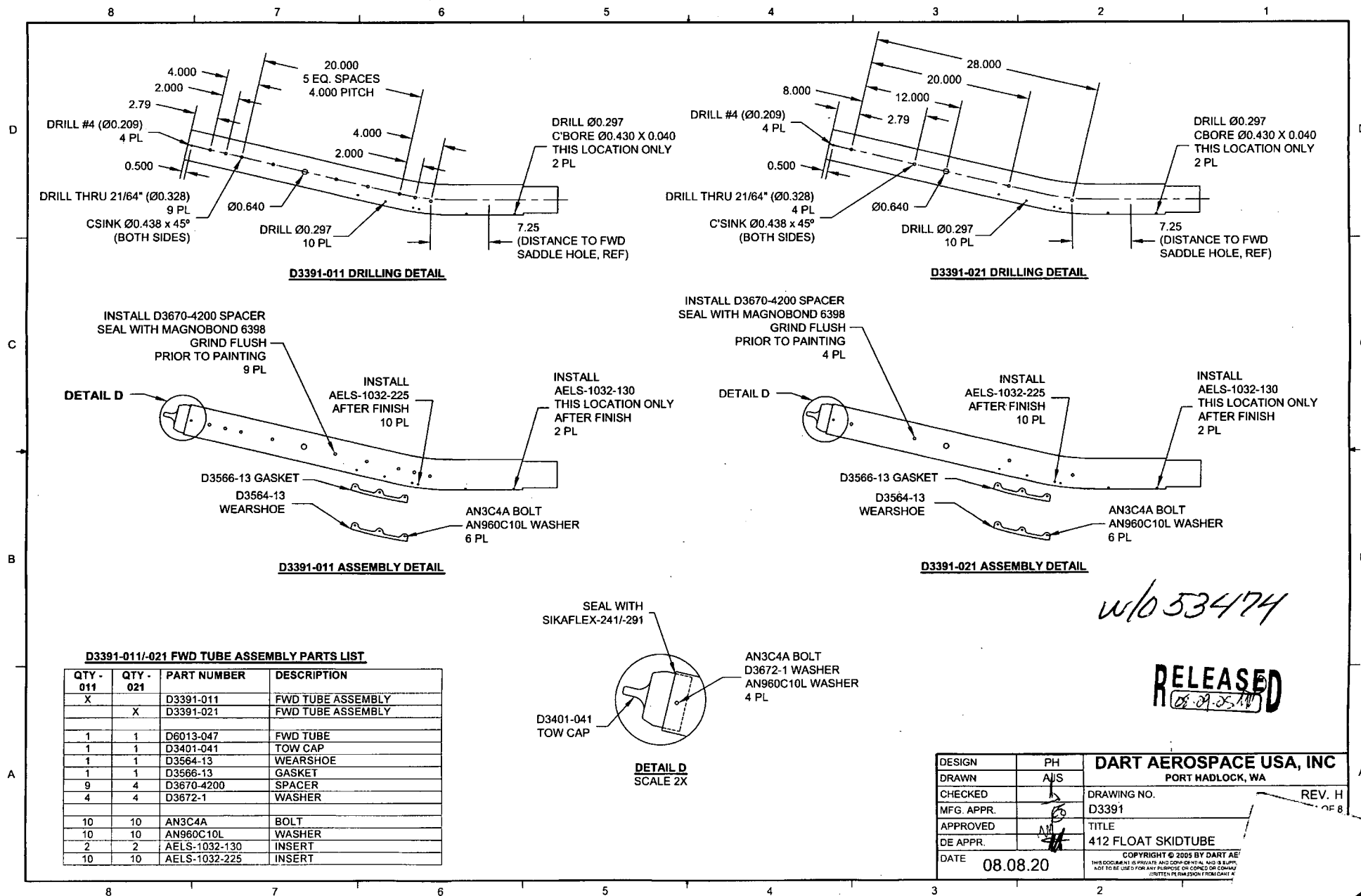
w/0 53474

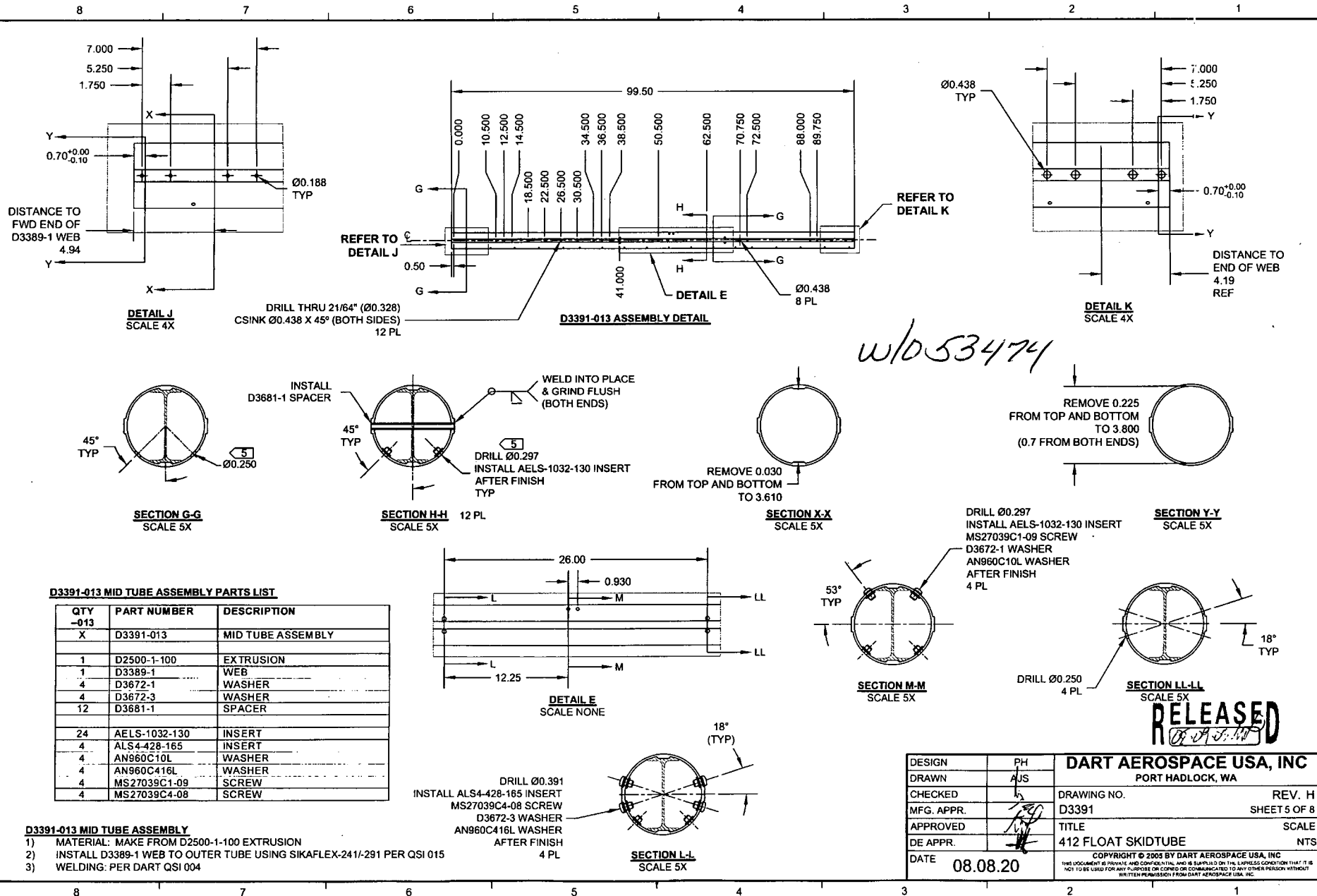


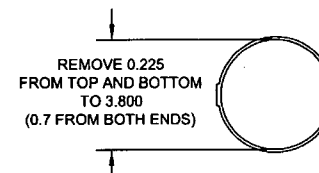
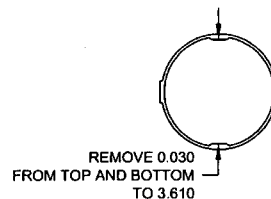
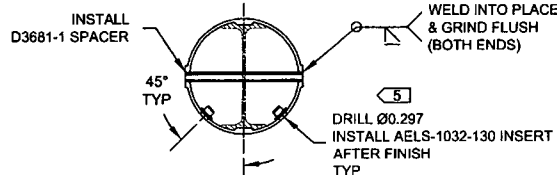
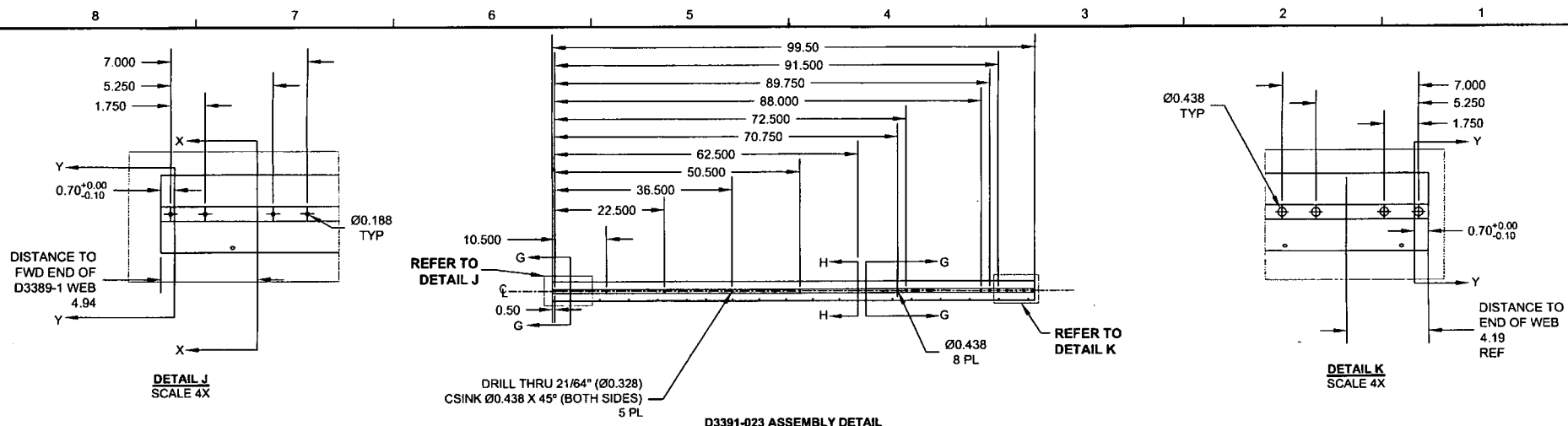
VIEW Z-Z
SCALE 2X

RELEASED
08-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	







D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

W/O 534741

RELEASED
08-08-20

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	AJS	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D3391 SHEET 6 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

